

Work Order ID 97226

February-14-13 1:10:20 PM

97226

Page 1

Item ID: D2885

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle Spacer

Start Date: 2/14/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/22/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-02-15 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2885	Rev B
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100	FLOW WATER JET	0.00							
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100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2885

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

20

DAS
05
2-89

13-05-10

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

20

DAS
05
2-89

13-05-10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
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NCR: Yes / No

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20V

80

B-5-10

MLJ

13-05-13

mf

13-5-10

NCR: Yes / No

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Picklist Print

February-14-13 10:54:05 AM

Page 1

Work Order ID: 97226

Parent Item: D2885

Parent Item Name: Saddle Spacer

Start Date: 2/14/13

Required Date: 2/22/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A99.10.12New IssueEC
IPP Rev:B Now 6060-T6 06-06-23 JLM
IPP Rev:C waterjet 06-07-23 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	393.7686	0.0257	0.541052		2/13-05-10	

Location

Loc Qty

Loc Code

MAT021

393.768632

117285

0.248632

119766

39.82

120096

168.8

123279

40.9

124572

144

NCR: Yes / No

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DART AEROSPACE LTD		Work Order:	97226
Description: Saddle Spacer		Part Number:	D2885
Inspection Dwg: D2885 Rev: B		Page 1 of 1	

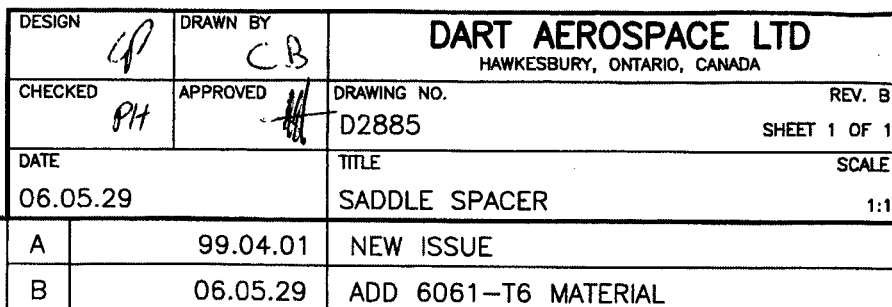
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

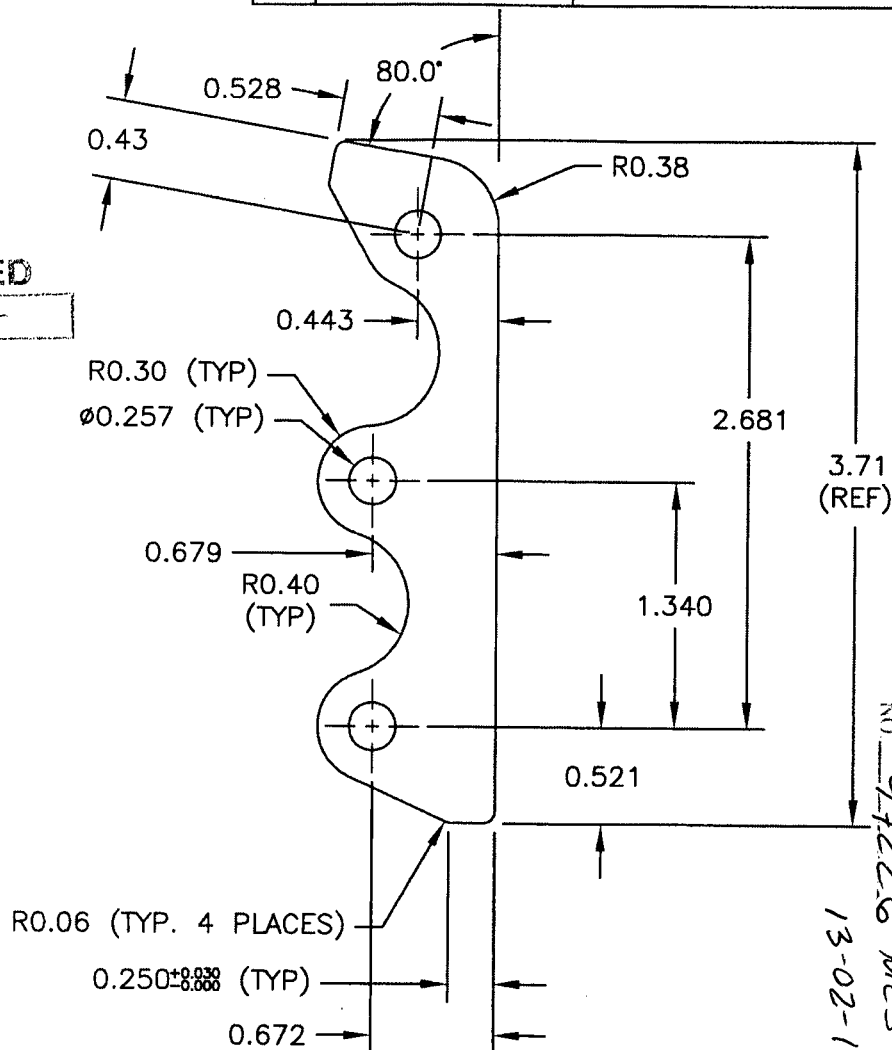
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	0.422	✓		✓	JRM-01
0.443	+/-0.010	0.442	✓		✓	
Ø0.257	+0.006/-0.001	0.257	✓		✓	
R0.30	+/-0.030	R0.30	✓		RG	
0.679	+/-0.010	0.673	✓		✓	
R0.40	+/-0.030	R0.40	✓		RG	
0.250	+0.030/-0.000	0.250	✓		✓	
0.672	+/-0.010	0.670	✓		✓	
0.521	+/-0.010	0.520	✓		✓	
1.340	+/-0.010	1.337	✓		✓	
2.681	+/-0.010	2.687	✓		✓	
3.71	+/-0.030	3.695	✓		✓	
R0.38	+/-0.030	R0.38	✓		RG	
0.528	+/-0.010	0.524	✓		✓	
0.080°	+/-0.5°	0.080	✓		AF	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 13.05.10	Date: 13.5.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	<i>[Signature]</i>



cf. cf. 20



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 97226

13-02-15

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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